

Date: Thursday, 6/15/2006 1:52:52 PM  
 User: Kim Johnston

## Process Sheet

|                       |  |                  |                 |
|-----------------------|--|------------------|-----------------|
| Customer              | : CU-DAR001 Dart Helicopters Services  | Drawing Name     | : STEP WELDMENT |
| Job Number            | : 27603  |                  |                 |
| Estimate Number       | : 10748  |                  |                 |
| P.O. Number           | : N/A  | Part Number      | : D34635        |
| This Issue            | : 6/15/2006 S.O. No. : N/A   | Drawing Number   | : D3463 REV.B   |
| Prsht Rev.            | : NC   | Project Number   | : N/A           |
| First Issue           | : N/A Type : PURCHASED PARTS   | Drawing Revision | : B             |
| Previous Run          | : 25529  | Material         | : N/A           |
| Written By            | : <u>See Comment Below</u>   | Due Date         | : 6/30/2006     |
| Checked & Approved By | : <u>See Comment Below</u>   | Qty:             | 4 Um: Each      |
| Comment               | : EST REV. A 05.11.18 NEW ISSUE EC<br>Est Rev:B Now on Waterjet 06-06-15 JLM |                  |                 |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 .063 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.0117 sf(s)/Unit Total : 0.0466 sf(s)  
 304/316 .063 Sheet  
 (M304S16GA)  
 Batch: MT106

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3463  
 Dwg Rev: B  
 Prog Rev: B

2-Deburr if necessary

SAD 06:06:19

④

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:06:19

④

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

See Comment Below

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: ST438

See Comment Below

④

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/27

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:52:52 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27603

Part Number: D34635

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

2006/06/27 (4)

Job Completion



u X627

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

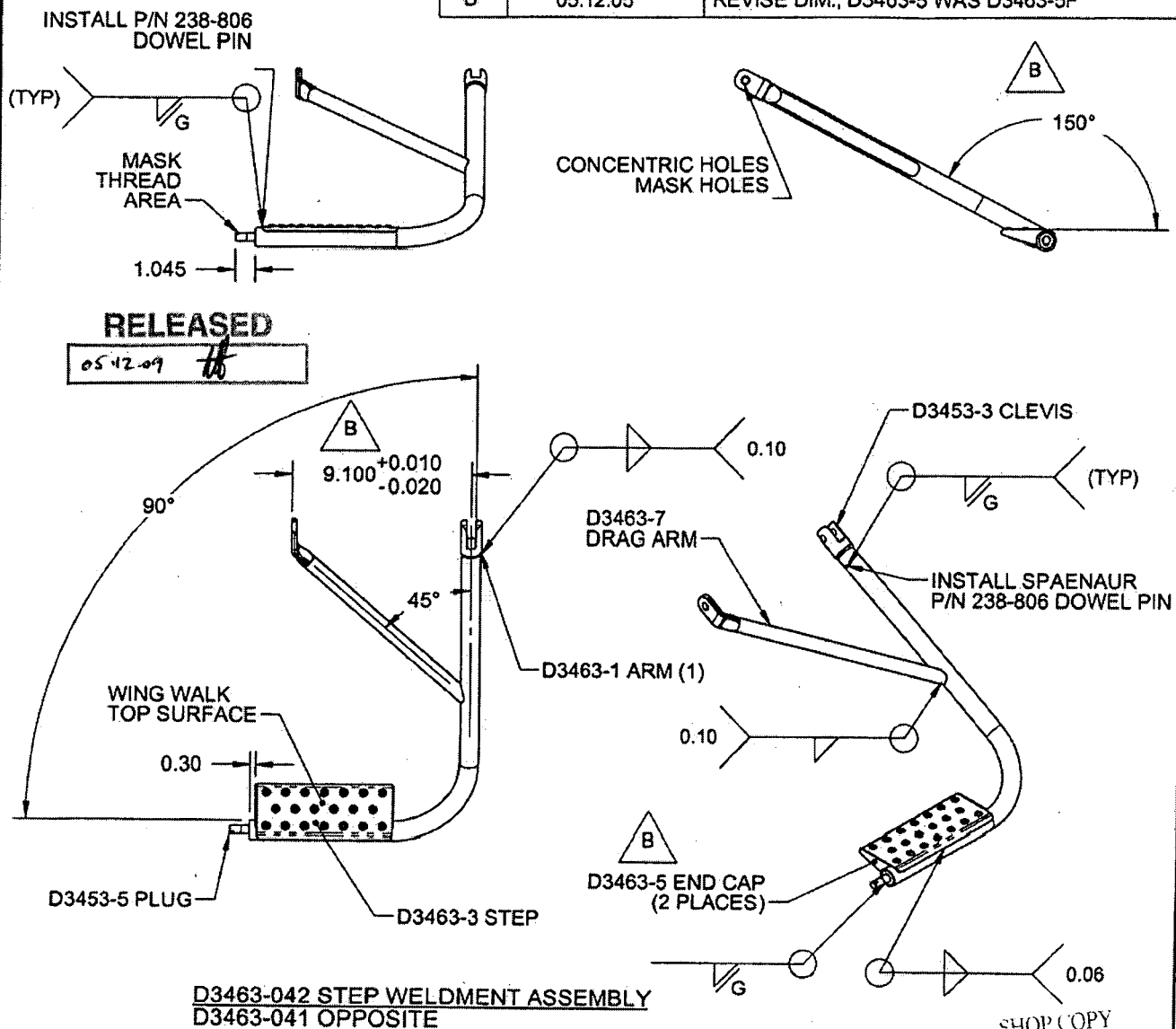
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

|                         |                |  |                        |
|-------------------------|----------------|--|------------------------|
| DESIGN<br>RF            | DRAWN BY<br>RF | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#            | APPROVED<br>#  | DRAWING NO.<br><b>D3463</b>                              | REV. B<br>SHEET 1 OF 4 |
| DATE<br><b>05.12.05</b> |                | TITLE<br><b>STEP WELDMENT</b>                            | SCALE<br>1:8           |
| A                       | 05.09.20       | NEW ISSUE  |                        |
| B                       | 05.12.05       | REVISE DIM.; D3463-5 WAS D3463-5F                        |                        |

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

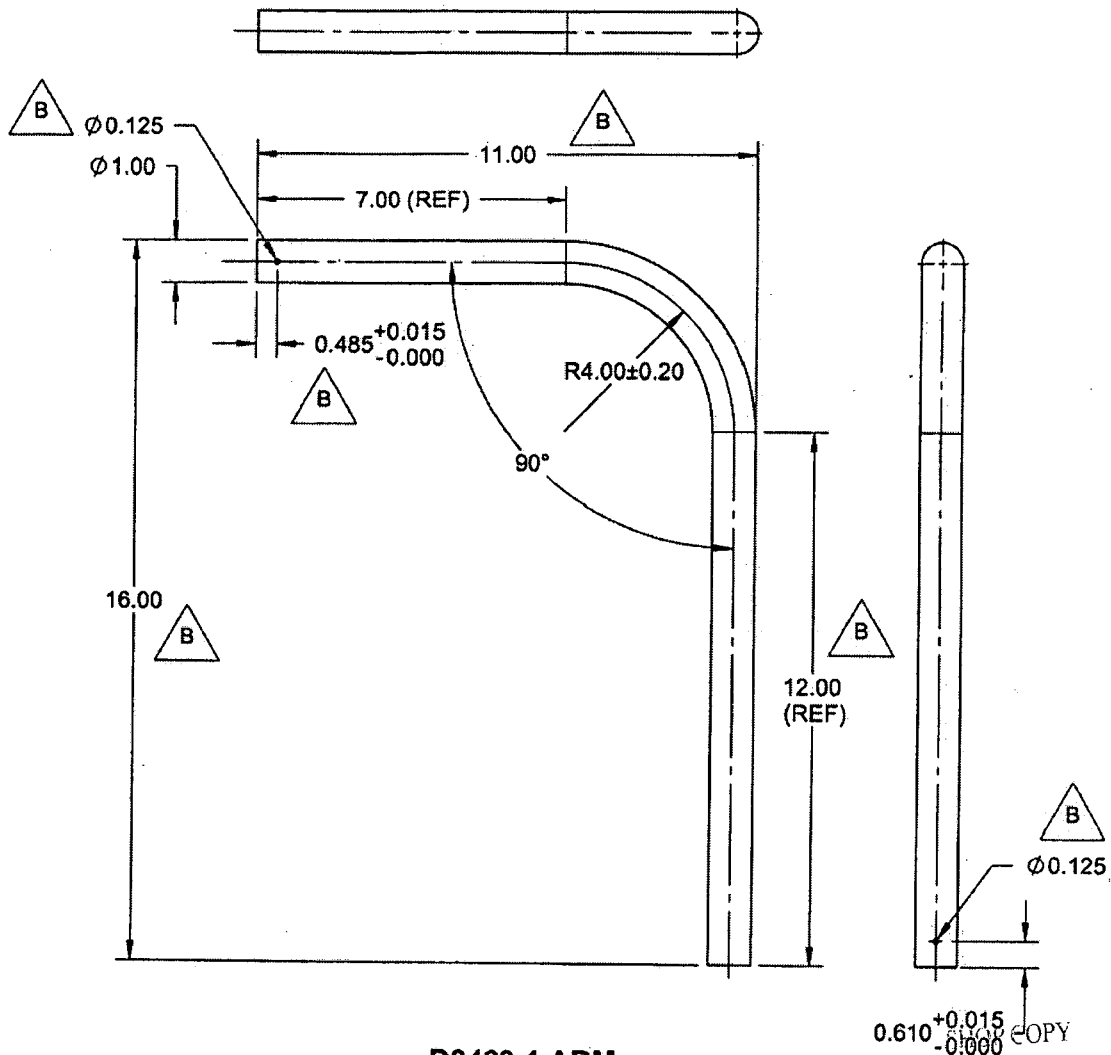
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**DART**

|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br>RF                  | DRAWN BY<br>RF                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3463</b>                              | REV. B<br>SHEET 2 OF 4 |
| DATE<br><b>05.12.05</b>       | TITLE<br><b>STEP WELDMENT</b>  |  | SCALE<br>1:4           |

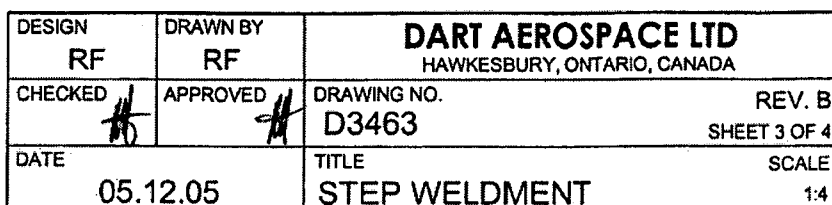
**RELEASED**05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

0.610 <sup>+0.015</sup>/<sub>-0.000</sub> COPY  
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05.12.09 ~~11~~



1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M  
2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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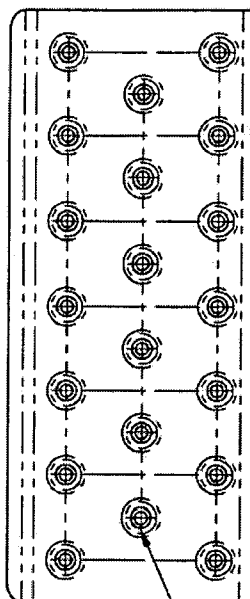
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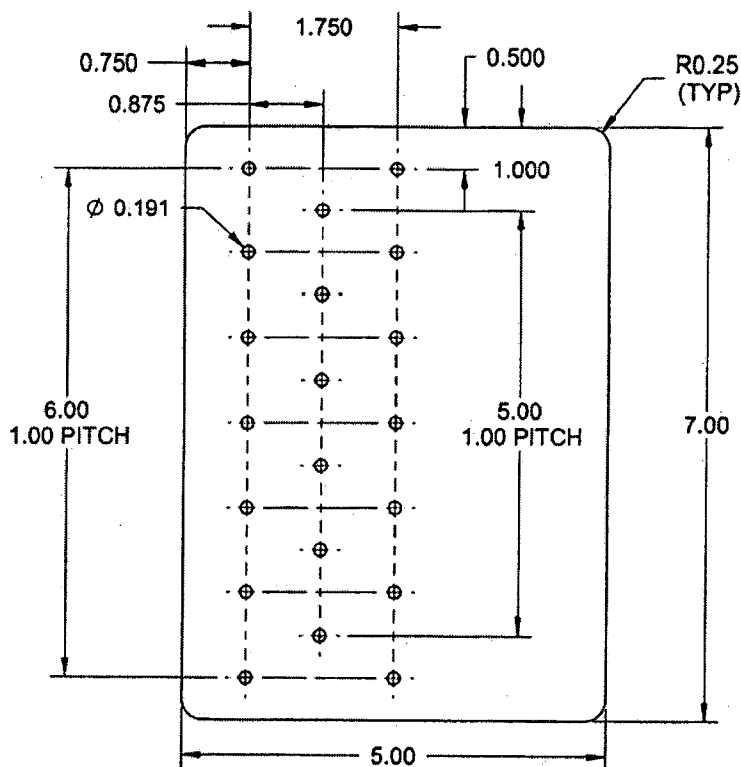
|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>RF     | DRAWN BY<br>RF | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D3463                              | REV. B<br>SHEET 4 OF 4 |
| DATE<br>05.12.05 |                | TITLE<br>STEP WELDMENT                            | SCALE<br>1:2           |

RELEASED

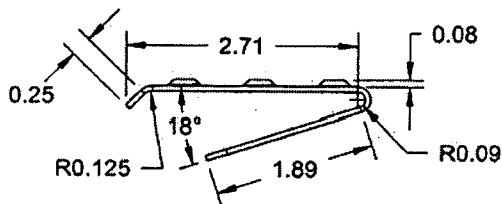
05.12.09 #



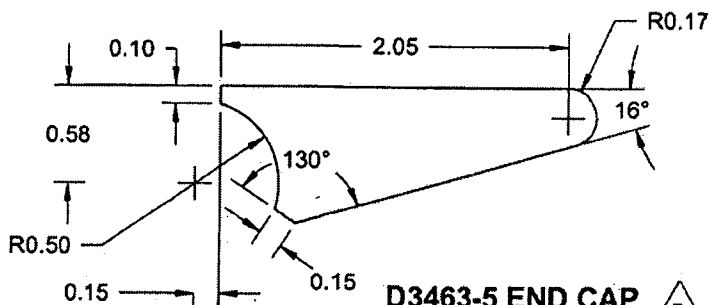
FORM USING  
D3463-3T1



**D3463-3F FLAT PATTERN**



**D3463-3 STEP**



**D3463-5 END CAP**  
SCALE 1:1

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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